

Date: Friday, 1/27/2006 7:54:16 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR WEDGE
Job Number :	25633		
Estimate Number :	12110		
P.O. Number :	N/A	Part Number :	D32001
This Issue :	1/27/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3200 REV A
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	A
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	2/15/2006
Written By :	SEE COMMENT BELOW	Qty:	50
Checked & Approved By :	JF 06.01.27	Um:	Each
Comment :	Est Rev:A Removed from 9 Digit 06-01-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.0525 sf(s)/Unit Total : 2.6250 sf(s)
 UHMW 1" Black
 Material: Black UHMW 0.95" or 1.00" thick
 Use bearpaw scrap material
 (MUHMWB10)
 Identify for D3200-1
 Batch: M15411

JF 06/02/20 52

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 2.700" x 2.700

JF 06/02/20 52 PTO

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3200-1 as per Folio FA337 and Dwg D3200

2-Deburr

JF 06/02/23 50

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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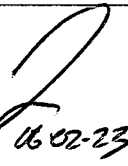
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 06/02/23 50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/24	3	one piece the engraving too deep. two piece the chanfer was wrong	CP 06.02.24 per QS1042	destroy and replace	J.F. 06/02/23	 06.02.23	CP 06.02.24 per QS1042	 06.02.23

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR WEDGE

Job Number: 25633

Part Number: D32001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/02/23 50

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST413

CL 06/02/23 50

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

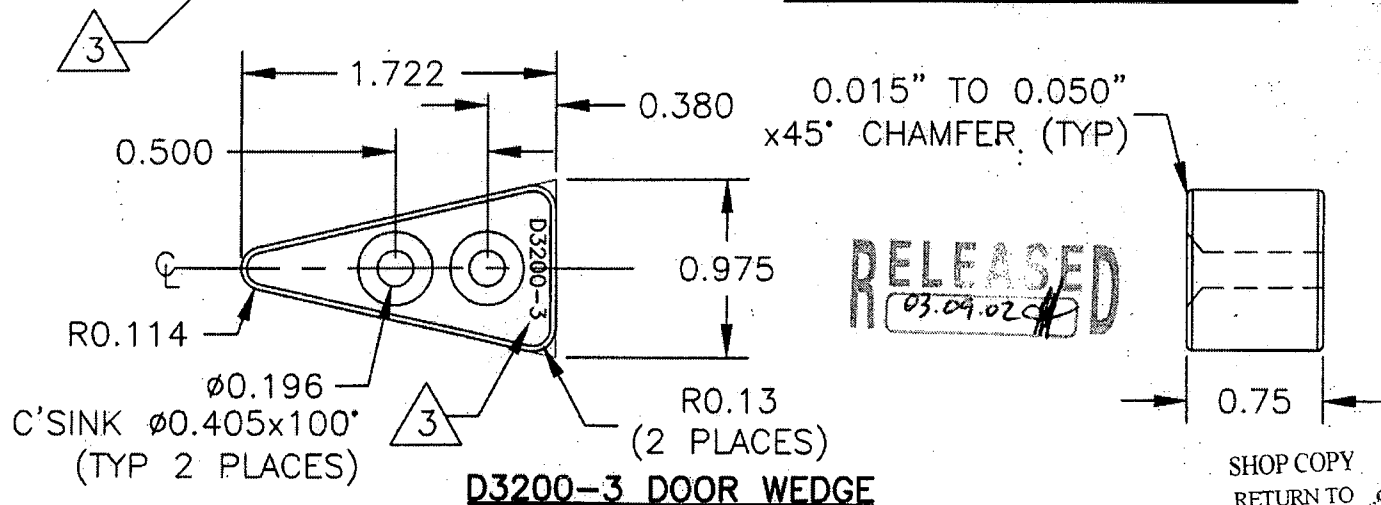
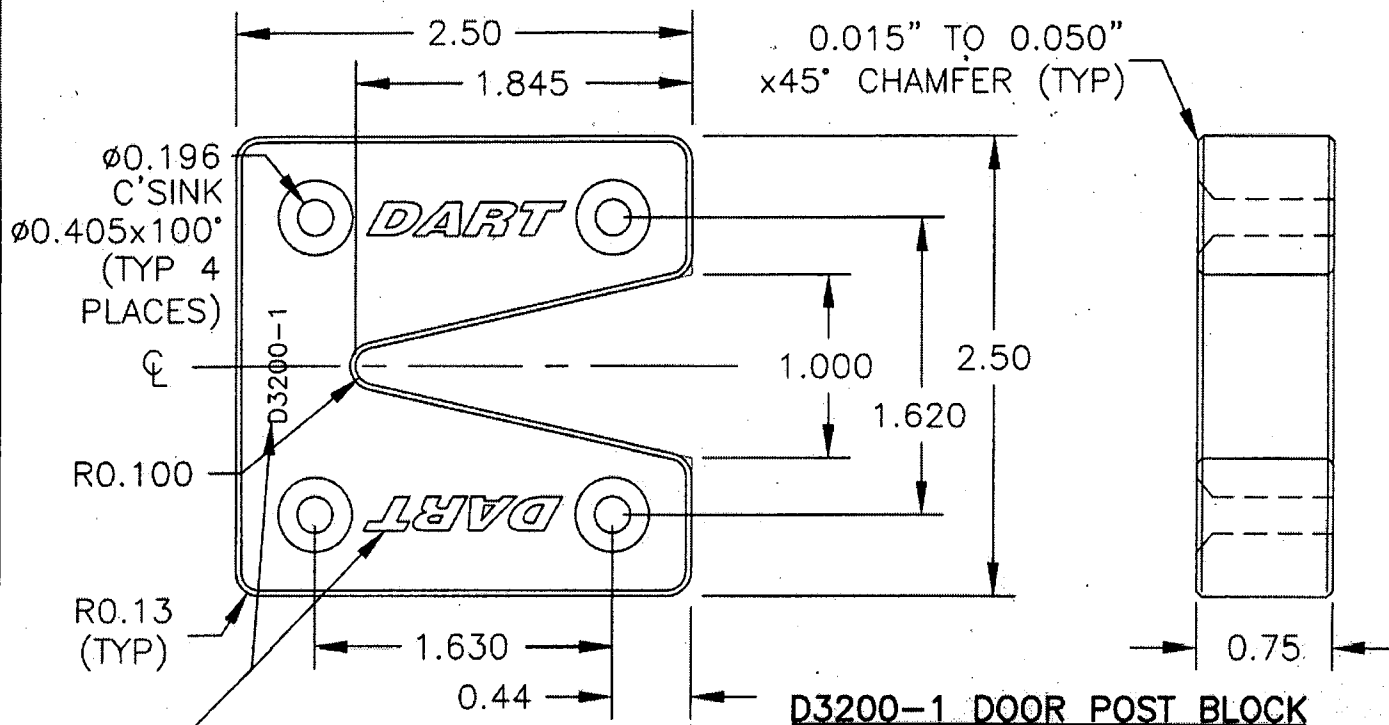
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06		TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06	NEW ISSUE	



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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03.09.02

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WORK ORDER

NO. 25633